

Date: Tuesday, 07/10/2008 10:16:39 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LEFT ARM WELDMENT
<b>Job Number</b> : 42495	
<b>Estimate Number</b> : 12080	
<b>P.O. Number</b> :	<b>Part Number</b> : D33543
<b>This Issue</b> : 07/10/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3354 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 36649	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/10/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 28-10-07</u>	
<b>Comment</b> : est rev A 06.01.23 new issue EC Est Rev:B 07-12-10 rev C dwg DD verified by:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4130NR1250	4130N ROUND BAR 1.250
		(8)
<b>Comment:</b> Qty.: 0.6300 f(s)/Unit Total : 6.3000 f(s) <u>M106961 x 5</u> AISI 4130 ROUND BAR 1.250" dia. batch: <u>44106</u> <u>M103433 x 3</u> <u>mmf 08/10/16</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		(8)
<b>Comment:</b> 1-TURN AS PER FOLIO FA623 & DWG D3354 FOLIO REV: <u>B</u> DWG REV: <u>C</u> 2-DEBURR AS REQUIRED <u>mmf 08/10/16</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		(8)
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>mmf 08/10/16</u>		
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
<b>Comment:</b> CONVENTIONAL MILLING MACHINE 1-Drill cotter pin hole as per dwg D3354 2-Deburrr <u>mmf 08/10/17</u>		
5.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK <u>J.A. 08/10/17</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 07/10/2008 10:16:39 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEFT ARM WELDMENT

Job Number: 42495

Part Number: D33543

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



8x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Cart

8/10/20

SL

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Wheel Shaft		<b>Part Number:</b>	D3354-3
<b>Inspection Dwg:</b> D3354	<b>Rev:</b> C	<b>Page 1 of 1</b>	

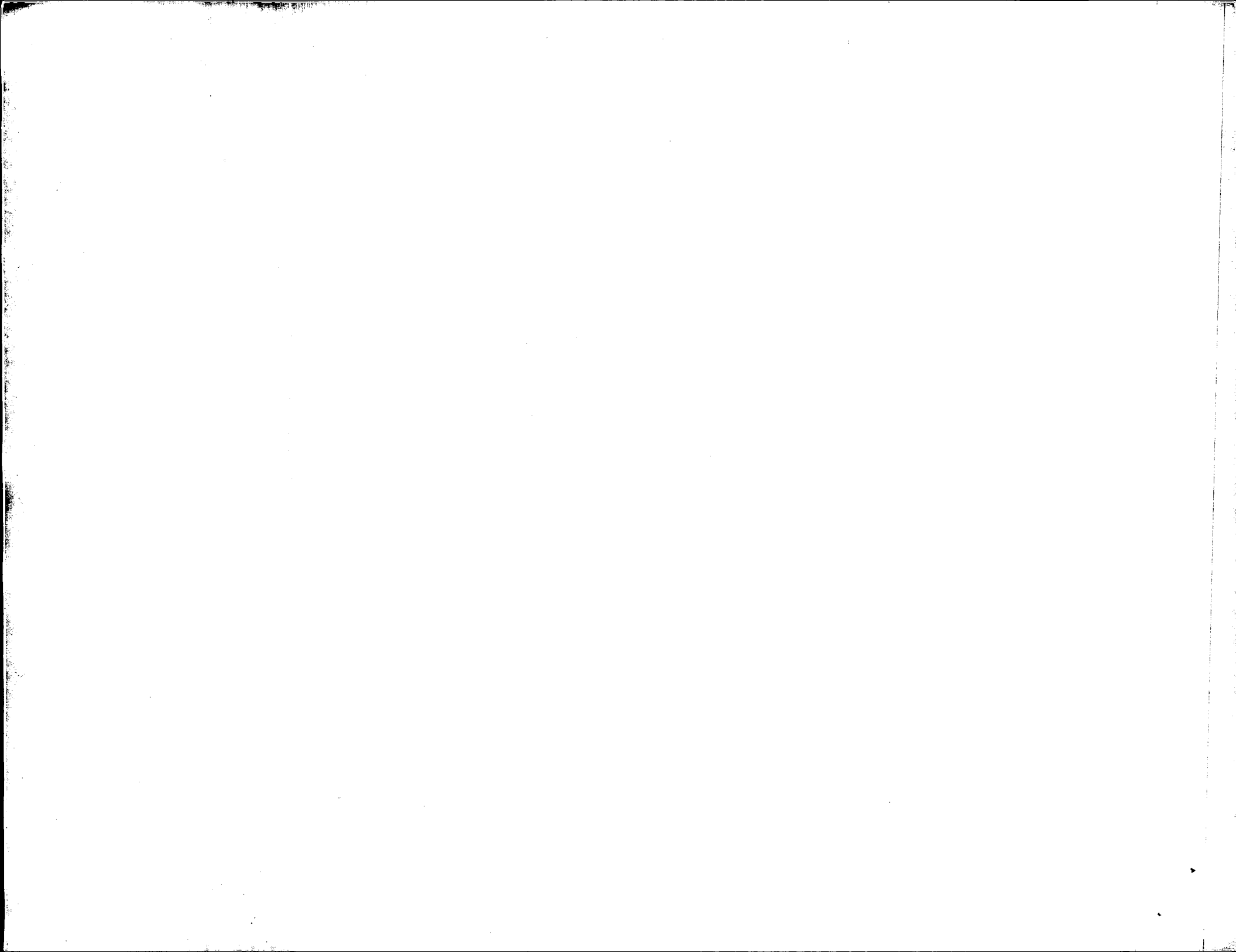
### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.04	+/-0.030	7.04	✓			
4.020	+0.010/-0.000	4.025	✓			
0.85	+/-0.030	.84	✓			
0.06	+/-0.030	.06	✓			
0.13	+/-0.030	.14	✓			
Ø1.250	+0.001/-0.004	Ø1.248	✓			
Ø1.103	+0.001/-0.002	Ø1.102	✓			
0.750 Thread	+/-0.010	.750	✓			
0.03 x 45°	+/-0.030 x 0.5°	.03 x 45°	✓			
Ø0.152	+0.005/-0.001	Ø.152	✓			
R0.02	+/-0.030	R.02	✓			
R0.050	+/-0.010	R.050	✓			
0.660	+/-0.010	.658	✓			

<b>Measured by:</b> <i>MMF</i>	<b>Audited by:</b> <i>H.A</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <i>08/10/17</i>	<b>Date:</b> <i>08/10/17</i>	<b>Date:</b>	N/A

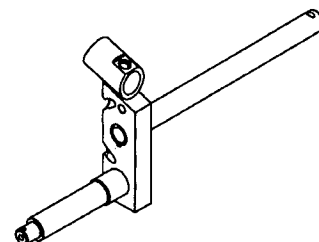
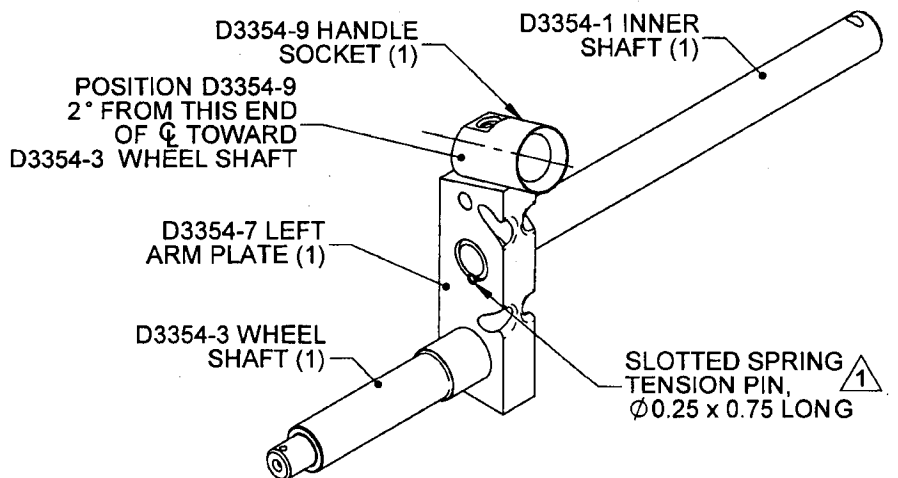
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.04.20	Ø0.152 dimension removed.	KJ/JLM	
C	08.01.16	Dwg Rev updated	KJ/EC/DD	<i>[Signature]</i>





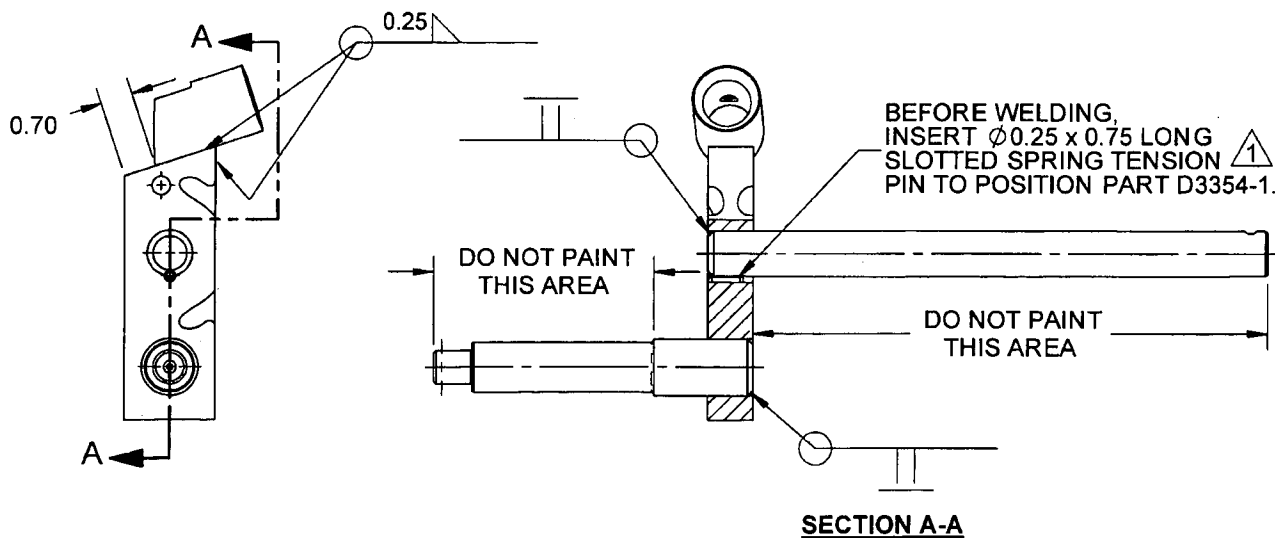
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CHECKED <i>lb</i>	APPROVED <i>MP</i>	DRAWING NO. <b>LEFT ARM WELDMENT</b>	REV. C SHEET 1 OF 7
DATE <b>07.12.06</b>		TITLE <b>D3354</b>	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	
C	07.12.06	CHANGE TOLERANCE ON D3354-7 LEFT ARM PLATE HOLE FOR D3354-3 WHEEL SHAFT	

RELEASED  
07/12/07 *MP*



**D3354-042 MIRROR  
ARM WELDMENT**

**D3354-041 LEFT ARM WELDMENT**



**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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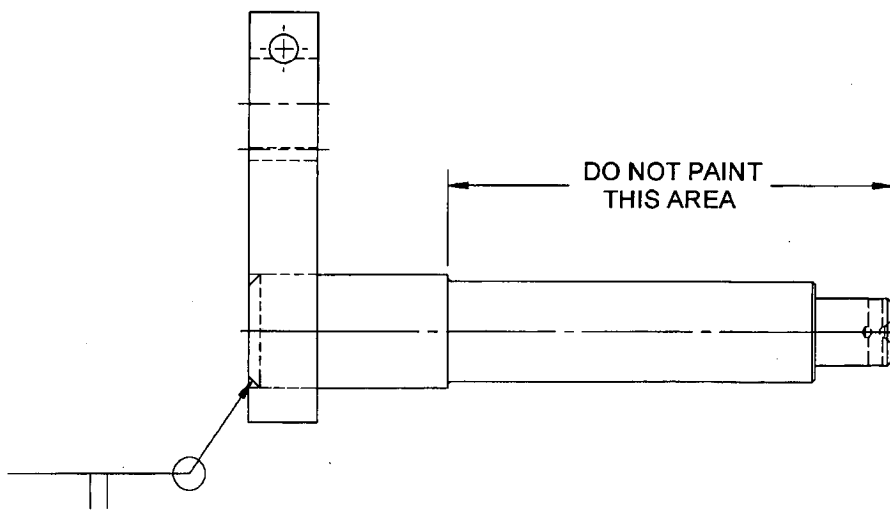
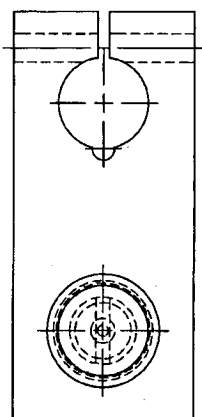
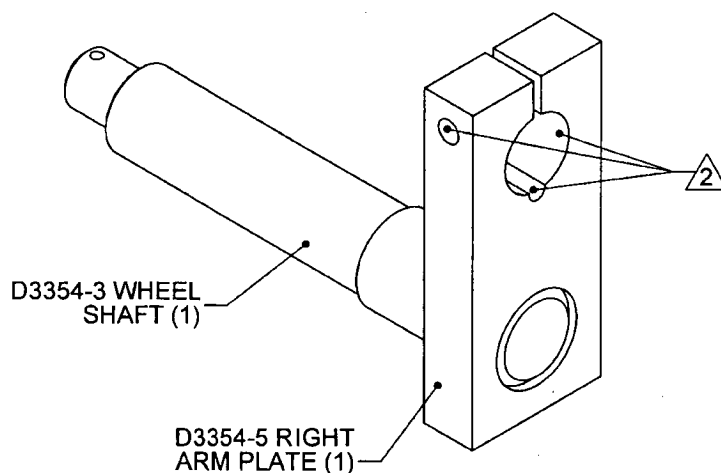
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CHECKED <i>12</i>	APPROVED <i>MP</i>	DRAWING NO. D3354	REV. C SHEET 2 OF 7
DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED  
01/12/07 *WJ*



### D3354-043 RIGHT ARM WELDMENT

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005.4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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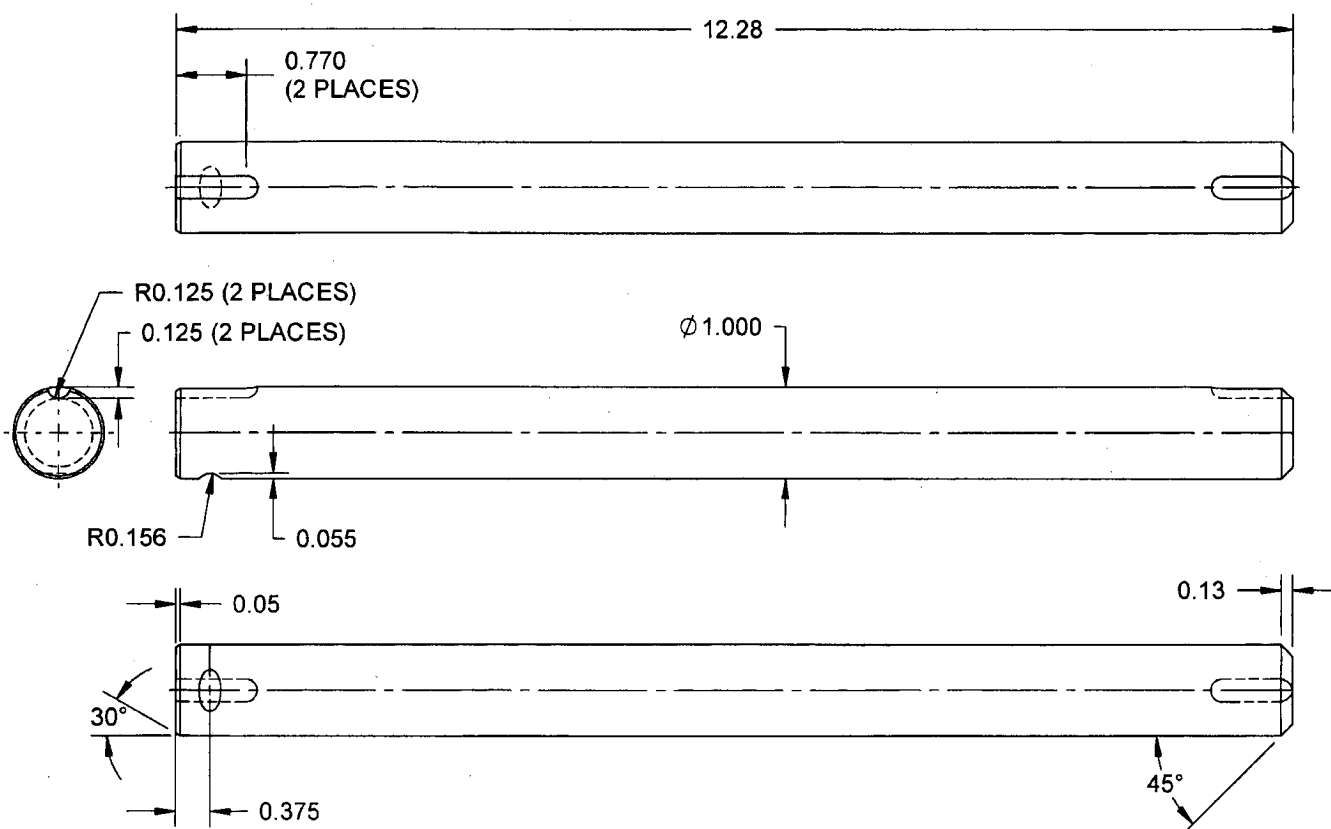
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CHECKED <i>JP</i>	APPROVED <i>MP</i>	DRAWING NO. D3354	REV. C SHEET 3 OF 7
DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED  
01/12/07 *W*



### D3354-1 INNER SHAFT

#### NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR,  $\phi$  1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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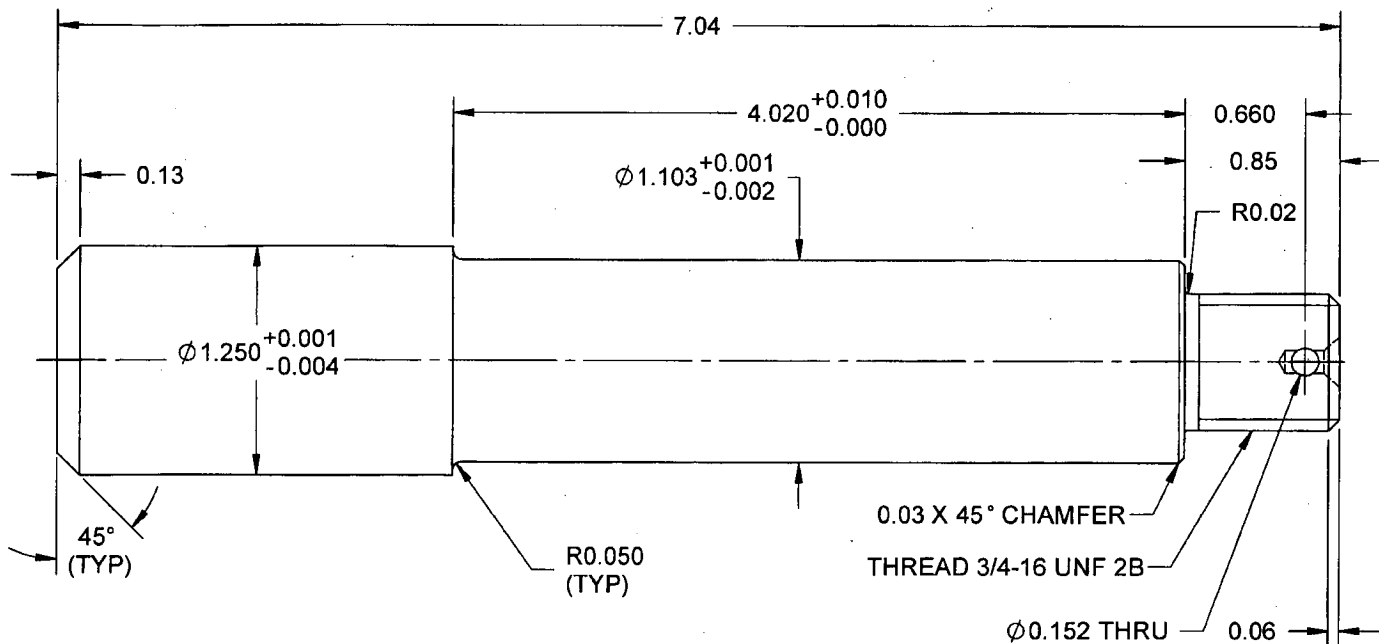
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CHECKED <i>JS</i>	APPROVED <i>MP</i>	DRAWING NO. D3354	REV. C SHEET 4 OF 7
DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:1

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07.12.07 *MA*



### D3354-3 WHEEL SHAFT

#### NOTES:

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91  
OR UNS#-G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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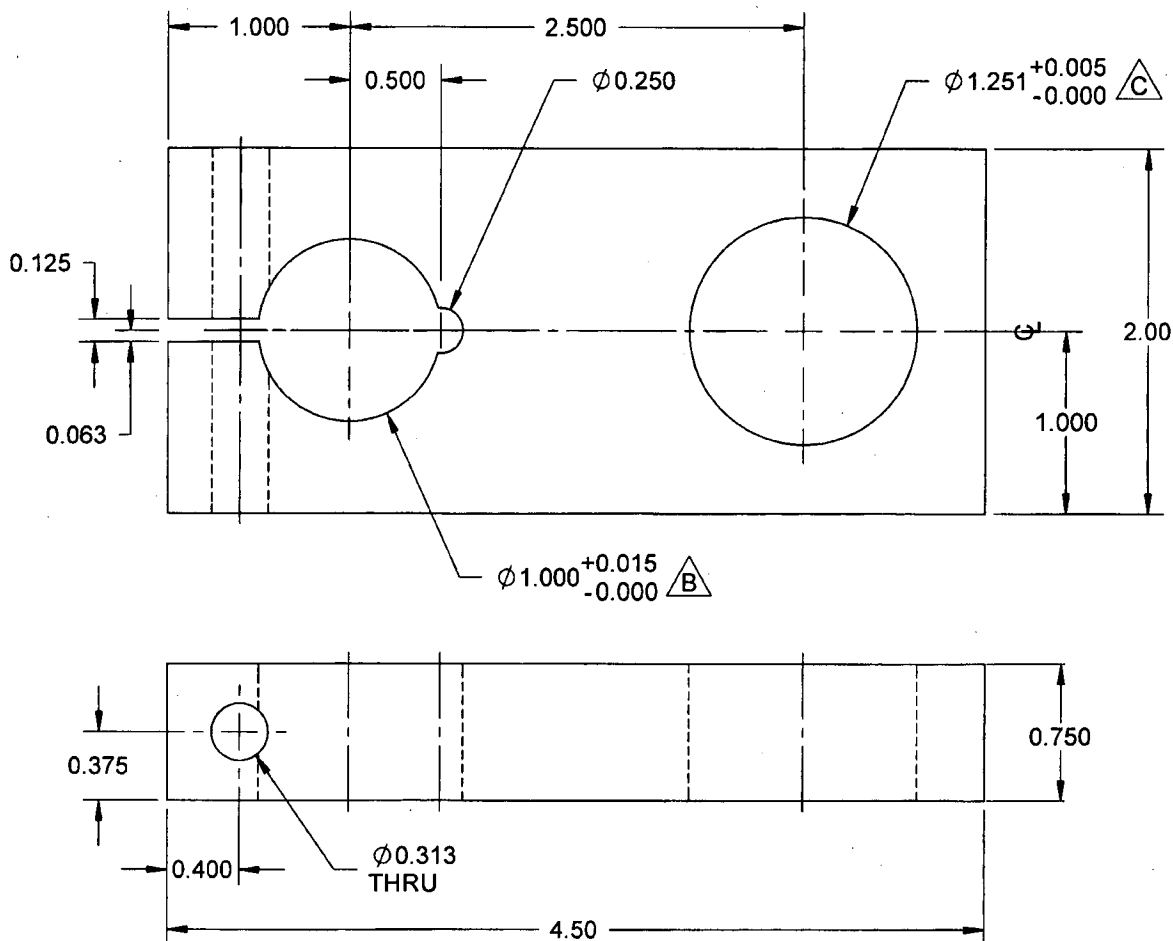
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12/1/54



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3354</b> REV. C SHEET 5 OF 7
DATE <b>07.12.06</b>	TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:1

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07/12/07 *[Signature]*



### D3354-5 RIGHT ARM PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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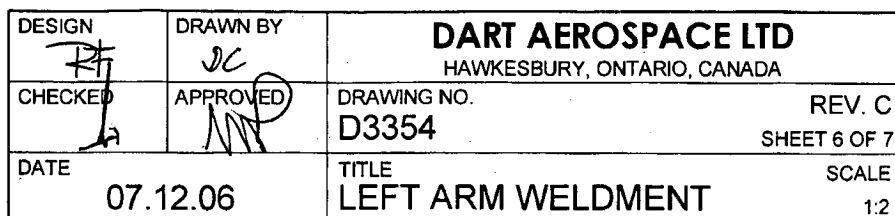
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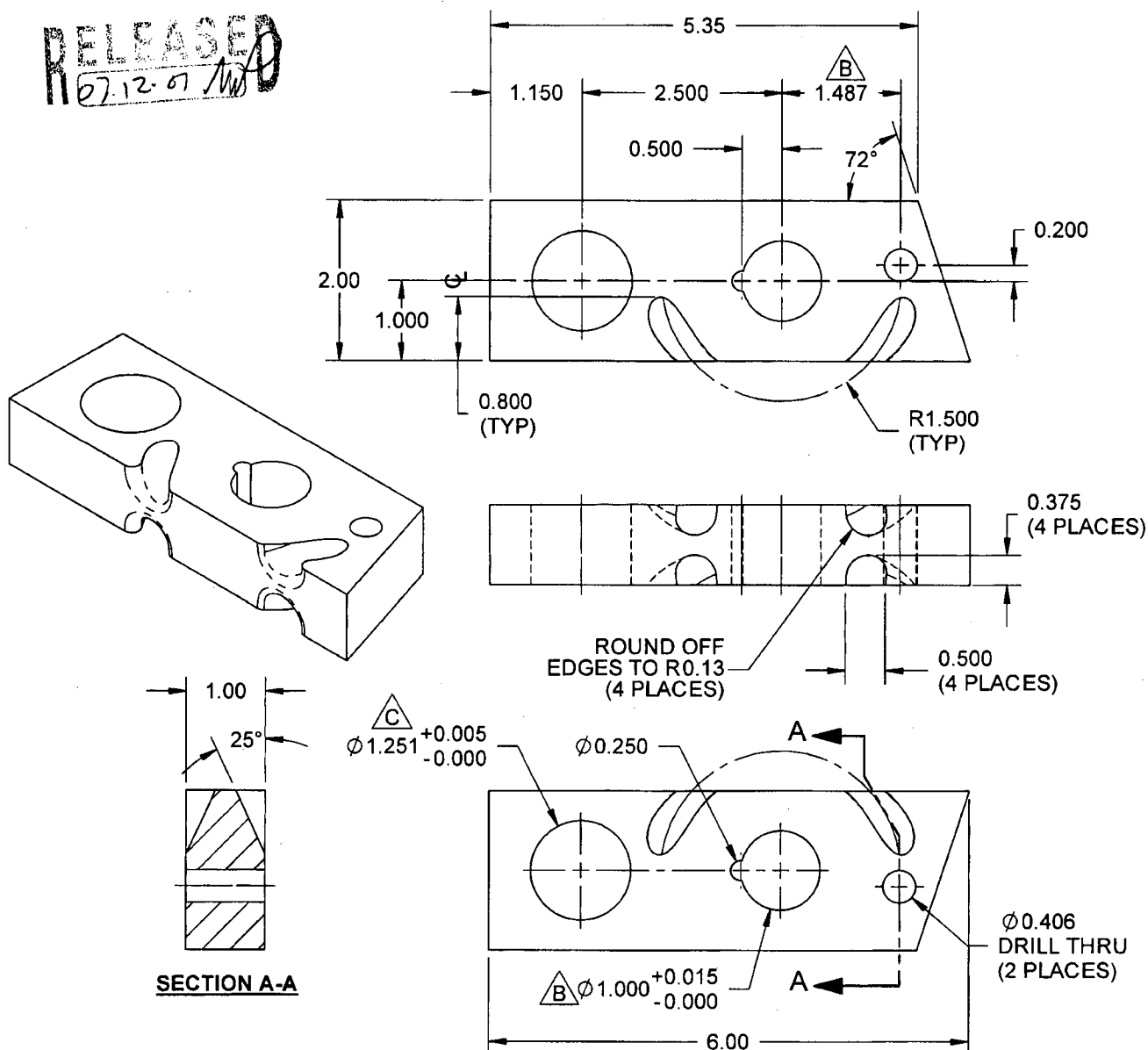
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07.12.07 *MSD*



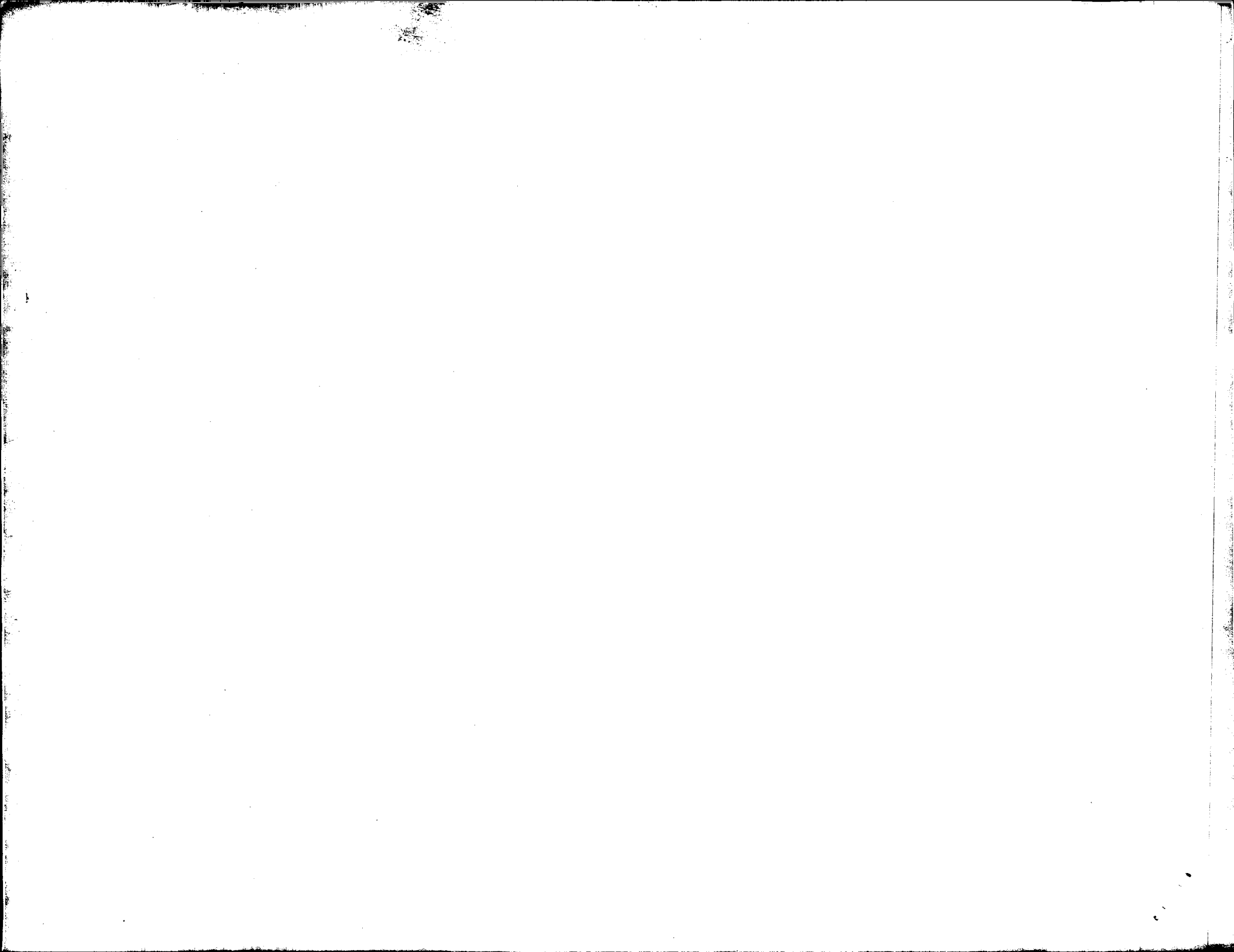
**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR  
CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD  
STEEL BAR (REF. DART SPEC. M1010-B)  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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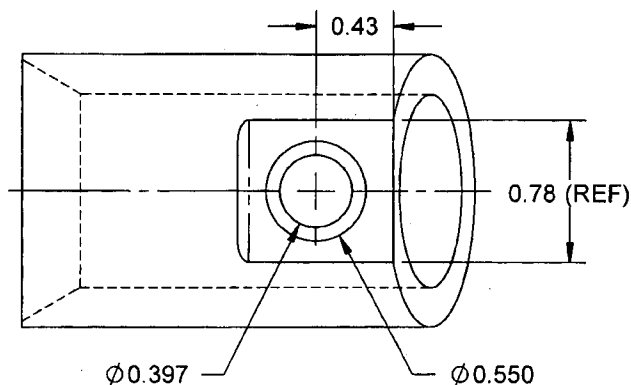
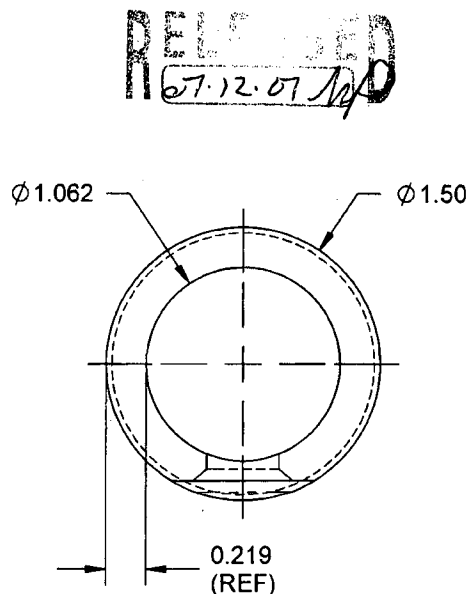
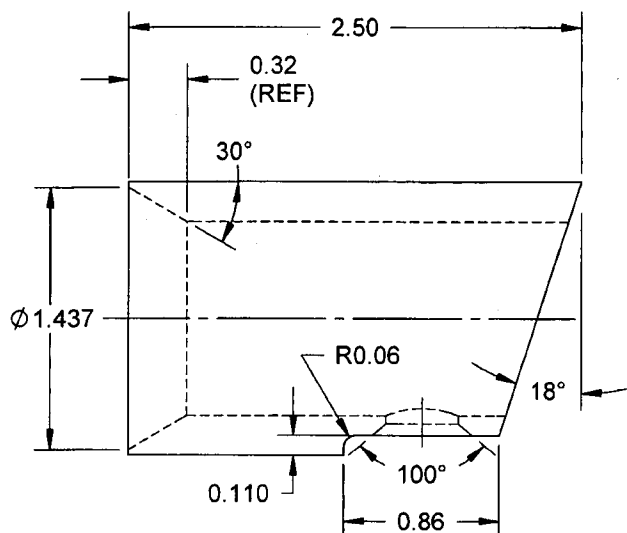
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CHECKED <i>LS</i>	APPROVED <i>MP</i>	DRAWING NO. <b>D3354</b>	REV. C SHEET 7 OF 7
DATE <b>07.12.06</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:1

**D3354-9 HANDLE SOCKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART.QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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